

Date: Tuesday, 10/06/2008 12:54:15 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET, GAS SPRING STUD		
Job Number	: 39781					
Estimate Number	: 10183					
P.O. Number	:			Part Number	: D2154	
This Issue	: 10/06/2008		S.O. No.	: D2154 REV. C		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 33886			~Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08 10-10</u>			Due Date	: 17/06/2008	
Comment	: Est: C 03.08.08 Reformat; Remove Tumble KJ/RF Est Rev:D NowOn Waterjet 07-04-09 JLM			Qty:	30	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
	Comment: Qty.: 0.0350 sf(s)/Unit Total : 1.0490 sf(s) 304/316 .063 Sheet Batch: <u>108090</u>	<u>BS 8-6-10</u>
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2154 Dwg Rev: <u>E</u> Prog Rev: <u>E</u>	<u>BS 8-6-10</u>
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>BS 8-6-10</u>
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<u>S08/06/11 140</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary	<u>08/06/10 140 1hr</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2154 Rev: C

SB 08/06/16

7.0 QC5 INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 08/06/16

X40

8.0 POWDER COATING POWDER COATING



m107928

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 9:10

1000°

OVEN TEMPERATURE: 1000°

FINISH TIME: 9:40

F2/12/17 08/06/17 X40

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



gf

Comment: INSPECT POWDER COAT

08-06-17

X40

10.0 PACKAGING 1 PACKAGING RESOURCE #1



X40

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 17

8/4/17

SP

11.0 QC21 FINAL INSPECTION/W/O RELEASE



08/06/1998

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/6/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification. Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39781
Description: Bracket, Stud	Part Number:	D2154
Inspection Dwg: D2154	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

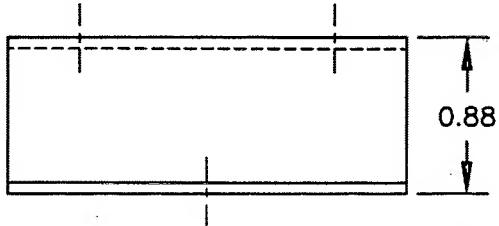
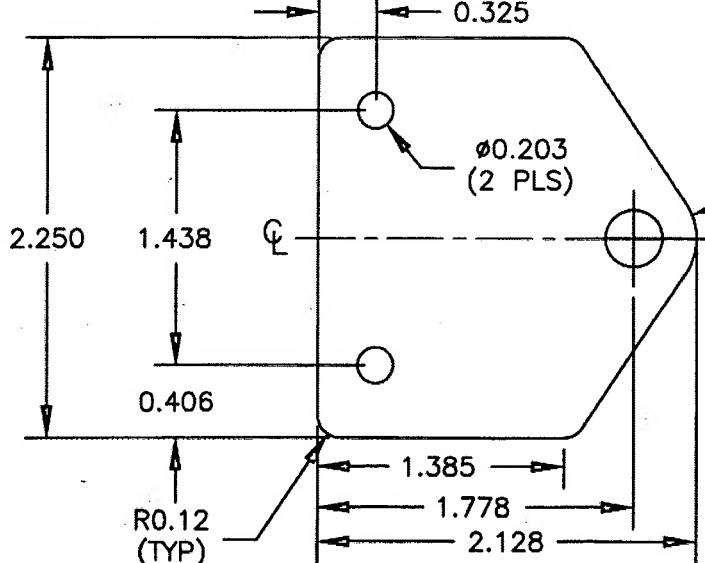
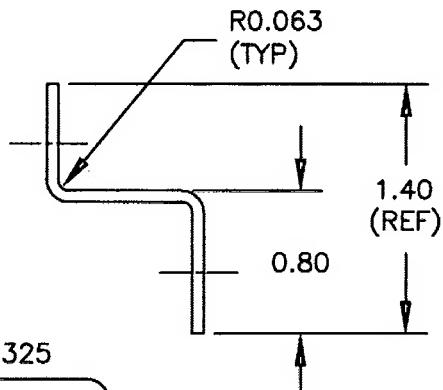
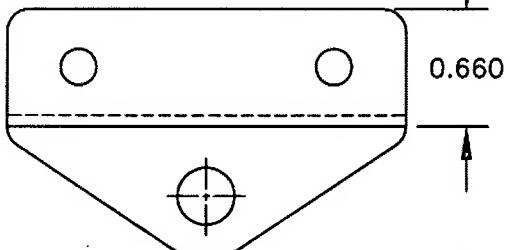
X First Article Prototype

Measured by: <u>KB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 8-6-10	Date: 08/06/11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.04.30	New Issue	KJ/JLM	
B	07.09.06	Ø0.320 dimension added	KJ/JLM	

DART

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154 REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD	SCALE 1:1

RELEASED04.10.15 *[Signature]***BEND DETAIL****FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39781

D2154 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

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